

D500-572-04

Work Order ID 67173

Wednesday, March 09, 2011 12:54:47 PM

Page 1

Item ID: D2435

Accept

Revision ID:

Item Name: Bearpaw, 206

Start Date: 3/9/2011 Start Qty: 4.00

Required Date: 3/16/2011 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2435

Rev E1

120

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT BLANK AS PER FILE D2435

B11-3-11

(4)

130

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
 2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435
 3-Deburr

SL 11/03/21

(4)

140

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 11/03/21

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67173

Wednesday, March 09, 2011 12:54:47 PM

Page 2

Item ID: D2435

Accept

Setup Start

Revision ID:

Stop

Item Name: Bearpaw, 206

Start Date: 3/9/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 3/16/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

K.A 11/03/22

4

0

151

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

P11/03/22

C4/3/22 G

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/22 J

C2 11/03/22

DART AEROSPACE LTD		Work Order: 67173
Description: Bearpaw		Part Number: D2435
Inspection Dwg: D2435 Rev: E1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.06 x 45°	/		Vern. JL-3	
B	5.500	+/-0.030	5.505	/		-	
C	0.200	+/-0.030	.193	/		-	
D	R0.250	+/-0.030	.250	/		R-G	
E	0.250	+/-0.010	.243	/		-	
F	0.625	+/-0.030	.618	/		-	
G	0.25 x 45°	+/-0.030	.270 x 45°	/		-	
H	0.375	+/-0.010	.369	/		-	
I	19.000	+/-0.030	19.00	/		m-type	
J	0.950	+0.030/-0.010	.942	/			
K	Ø0.260	+0.005/-0.000	.260	/		-	
L	Ø0.930	+/-0.030	.925	/		-	
M	0.30	+0.030/-0.000	.312	/		-	
N	0.375	+/-0.030	.378	/			
O	7.375	+/-0.030	7.374	/		VRINCNC-02	
P	4.250	+/-0.010	4.250	/		-	
Q	2.000	+/-0.030	1.999	/		-	
R	9.000	+/-0.010	9.00	/		-	
S	15.750	+/-0.030	15.750	/		m-type	

Measured by: SL	Audited by: HA	Prototype Approval:	N/A
Date: 11/03/21	Date: 11/03/22	Date:	

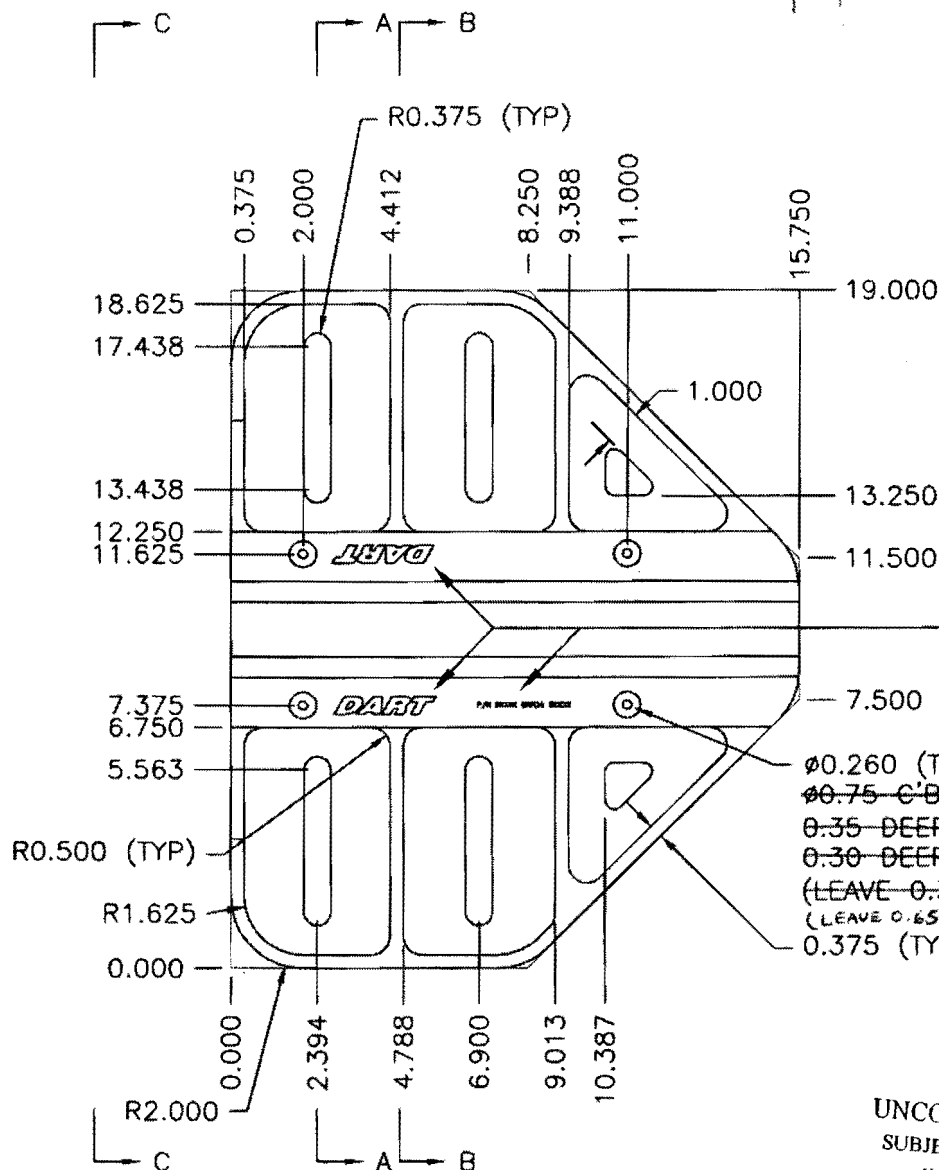
Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF	



RELEASED
98.06.17 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
KE	KE	
CHECKED	APPROVED	DRAWING NO.
KE	KE	D2435
DATE	TITLE	REV. E
98.05.19	BEARPAW	SHEET 1 OF 2
A	NEW ISSUE	SCALE 1:5
B	CHANGE BORE AND C'BORE DEPTH	
C	CHANNEL & C'BORE DEPTH CHANGED	
D	R1.5 BORE WAS R2.637 (TSR A469)	
E	CHANGE C'BORE, R1.58 WAS R1.50	

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)



Ø0.260 (TYP) Ø0.93 C'BORE
Ø0.75 C'BORE 0.30 DEEP FROM BOTTOM
0.35 DEEP FROM TOP (MIN.)
0.30 DEEP FROM BOTTOM
(LEAVE 0.300 MIN.)
(LEAVE 0.650 MIN.)
0.375 (TYP)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

9143

2011-03-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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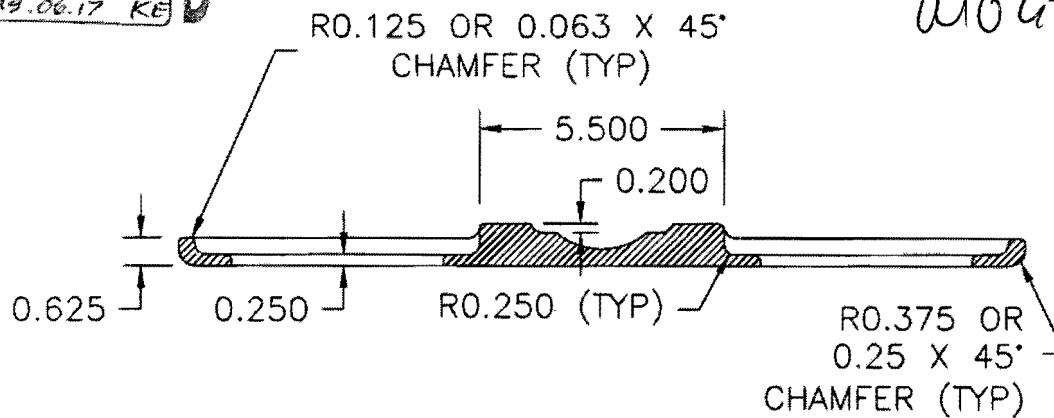
NOTE: Date & initial all entries



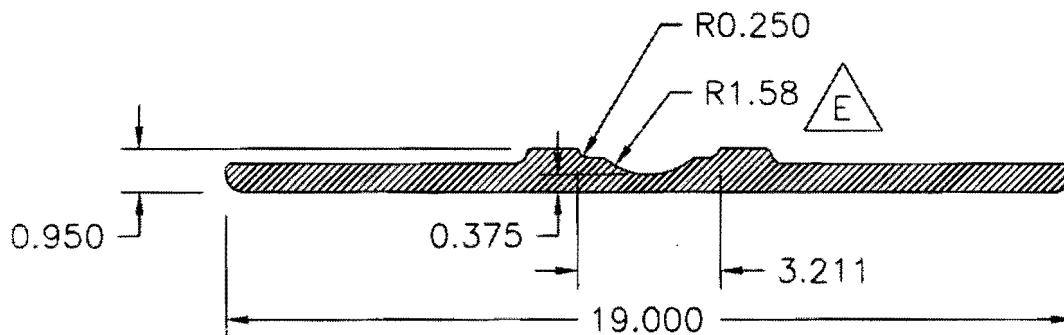
DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>DB</i>	APPROVED <i>JS</i>	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED
99.06.17 KE

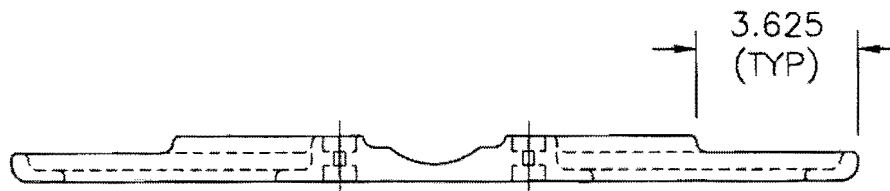
u661173



SECTION A-A



SECTION B-B



SECTION C-C

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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